



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBT400214-15
Job Sheet 189148



Part No: RBT400214-15

Job Qty: 20 pcs

Part Name: Frame



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/21/19

Job Tracking No:

Due Date: 2/15/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBT400214 Rev.7 IPP Rev. A 18.06.06 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
100	Waterjet - Omax - 1	20 pcs	2/15/19	2/15/19	0.00	1.67	Waterjet - Omax	dc 19/02/15
110	QC 2	20 pcs	2/15/19	2/15/19	0.00	0.00	QC 2 - 1	
							QC 2 - 12	
							QC 2 - 14	
							QC 2 - 17	
							QC 2 - 19	
							QC 2 - 2	
							QC 2 - 20	
							QC 2 - 22	
							QC 2 - 23	
							QC 2 - 25	
							QC 2 - 32	
							QC 2 - 33	
							QC 2 - 35	
							QC 2 - 38	
							QC 2 - 39	
							QC 2 - 4	
							QC 2 - 40	
							QC 2 - 44	
							QC 2 - 45	
							QC 2 - 48	dc 19/02/15
							QC 2 - 49	
							QC 2 - 50	
							QC 2 - 51	
							QC 2 - 52	
							QC 2 - 54	
							QC 2 - 56	
							QC 2 - 57	
							QC 2 - 62	
							QC 2 - 63	
							QC 2 - 8	

120 NV5000 - 2 - B4B	20 pcs	2/15/19	0.50 13.33	NV5000 - 1 - B4B	J.C.-L
				NV5000 - 2 - B4B	
130 QC 2	20 pcs	2/15/19	0.00 0.00	QC 2 - 1	
				QC 2 - 12	
				QC 2 - 14	
				QC 2 - 17	
				QC 2 - 19	
				QC 2 - 2	
				QC 2 - 20	
				QC 2 - 22	
				QC 2 - 23	
				QC 2 - 25	
				QC 2 - 32	J.C.-L 19-06-21
				QC 2 - 33	
				QC 2 - 35	
				QC 2 - 38	
				QC 2 - 39	
				QC 2 - 4	
				QC 2 - 40	
				QC 2 - 44	
				QC 2 - 45	
				QC 2 - 48	
				QC 2 - 49	
				QC 2 - 50	
				QC 2 - 51	
				QC 2 - 52	
				QC 2 - 54	
				QC 2 - 56	
				QC 2 - 57	
				QC 2 - 62	
				QC 2 - 63	
				QC 2 - 8	
140 QC 8	20 pcs	2/15/19	0.00 0.00	QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 38	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	gmm 17/07/14
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
150 Packaging 3-1 - Stock - B4B	20 pcs	2/15/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	

					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	EL
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
190	QC 21 - SA	20 pcs	2/15/19	0.00 0.00	QC 21 - SA - 21	JUL 16 2019
					QC 21 - SA - 70	

Part Op 100 - 1-Cut as per Dwg Dwg Rev: 1 Prog Rev: _____ 2-Debur if necessary

Descriptions: 110 - (QC2- Inspect parts off machine FAI/FAIB)

120 - NV5000-1 (MORI SEIKI VERTICAL MACHINE #1) 1-Machine as per folio FC296 FOLIO REV: AA DWG

REV: 1 2-Debur

130 - (QC2- Inspect parts off machine FAI/FAIB)

140 - (QC8- Inspect parts - second check)

150 - (Identify as per dwg & Stock Location: _____) IDENTIFY AND STOCK

190 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.250	6061T6 Sheet .250	9 sf (.45 ea)	100-Waterjet - Omax - 1	3152152

Job Allocations

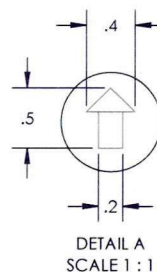
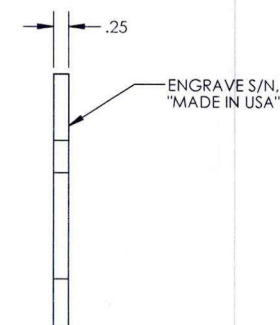
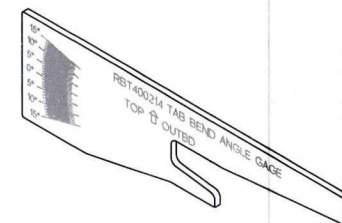
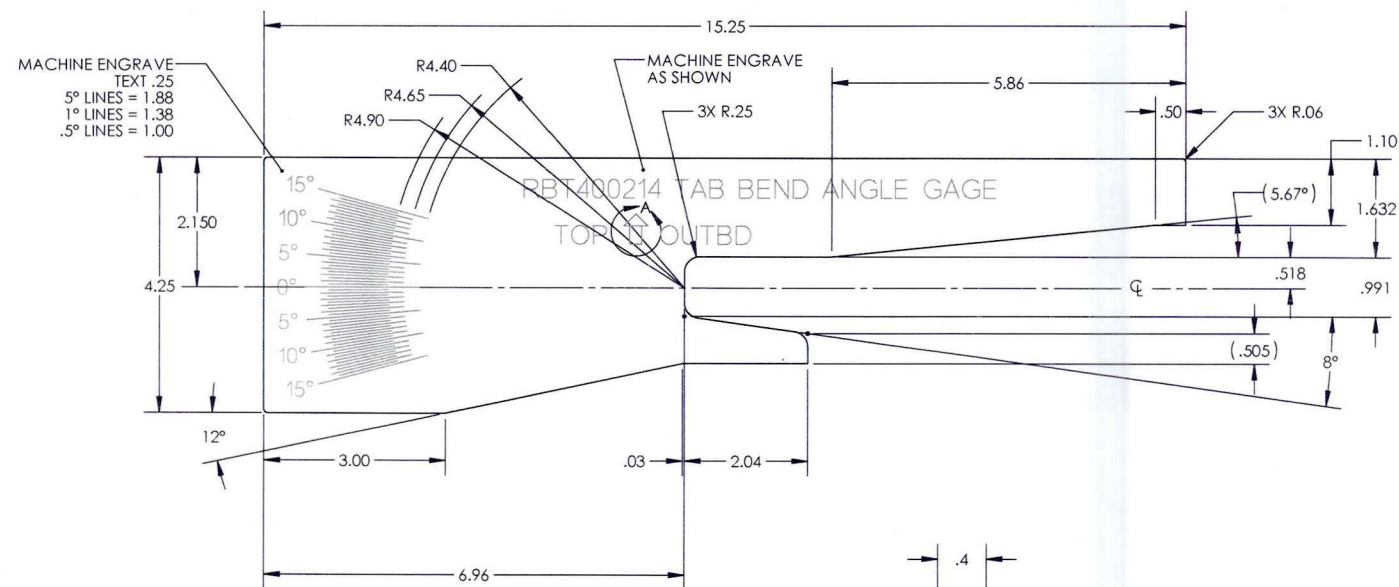
Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Omax - 1	M6061T6S.250	9	9	0

Part Specifications

Specifications could not be found.

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
3		REPLACED ANGLE GAUGE WITH A PLACARD, CREATED A POCKET FOR PLACARD IN FRAME PER S.E.	4/27/2011	RJC
4		DELETED POCKET FOR .21, ADDED MACHINE ENGRAVE GAUGE LINES & LETTERING.	6/28/2012	RJC
7	16-0240	-18 CH'D DIMS WAS 3X R.042 IS 3X R.06, WAS 4.250 IS 4.25, WAS 3.000 IS 3.00, WAS 6.960 IS 6.96, WAS R4.400 IS R4.40, WAS R4.650 IS R4.65, WAS R4.900 IS R4.90, WAS .032 IS .03, WAS 2.040 IS 2.04, WAS 5.857 IS 5.86, WAS .500 IS .50, WAS 1.100 IS 1.10, WAS 15.250 IS 15.25, WAS .250 IS .25, WAS R.250 IS R.25, WAS 1.875 IS 1.88, WAS 1.375 IS 1.38, WAS 1.000 IS 1.00, WAS .032 IS .03, DELETED DIM 1.021, ADDED DIM .991, ADDED ENGRAVE S/N, "MADE IN USA" NOTE.	12/1/2016	DPD



(-15)
FRAME

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 189148 MWS
190121

DART AEROSPACE	
TITLE TRIM TAB BENDING GAUGE	
DWG NO. RBT400214-15	REV 7
MAT'L 6061	UNLESS OTHERWISE SPECIFIED
FINISH SEE -1	DIMENSIONS ARE IN INCHES
	FRACTIONS ± 1/8
	ANGLES ± 5°
	SURFACES ± 125
DRAWN BY: COLE	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	0.15 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
SCALE 1:2	DATE 4/9/2001
	SHEET 9 OF 11

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

DART

AEROSPACE

Dart Aerospace Ltd.

1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S154339

Part: RBT400214-15

Job No: 189148

Serial No/Batch: S154339

Revision: 7

Inspector:

Exp Date:

Instructions:

Date: 02/5/19